

Date: Monday, 22/09/2008 2:09:14 PM
 User: Julie Lecocq

Process Sheet

SPWT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CABIN DOOR ROLLER KIT, RH					
Job Number	: 42196			Part Number	: D412698012					
Estimate Number	: 10289			Drawing Number	: IIN D412-698 REV D					
P.O. Number	:			Project Number	: N/A					
This Issue	: 22/09/2008	S.O. No.	:	Drawing Revision	: D					
Prsht Rev.	: NC	Type	: MACHINED PARTS	Material	:					
First Issue	: / /			Due Date	: 20/10/2008					
Previous Run	: 40224			Qty:	(1) Um: Each					
Written By	:			22						
Checked & Approved By	<i>JLD 08.08.08</i>									
Comment	: Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS									
	Est Rev:D 08-01-28 change to rev D ECN 1104 DD									

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	<i>A for JLD 08.10.08</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-698-012 CHG003	<i>S 08/12/12</i>
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D3121141	Bracket Assembly	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 66.0000 Each(s) Pick: Packing Kit	<i>P</i>
		Qty Part Number Description Batch	<i>3 D3121-141 Bracket Assembly 92189</i>
4.0	D3121144	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s) Pick: Packing Kit	<i>P</i>
		Qty Part Number Description Batch	<i>1 D3121-144 Bracket Assembly 13421915X B43487 17X 10</i>
5.0	D3137043	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s) Pick: Packing Kit	<i>P</i>
		Qty Part Number Description Batch	<i>1 D3137043 Bracket Assembly B29 725 P 8/12/9 (22)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CJ-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 42196

Part Number: D412698012

Job Number:



Seq. #: Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly _____

6.0 D3183044 Bracket Assembly

HTT
HTT



S Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

HTT Qty Part Number Description Batch
1 D3183-044 Bracket Assembly *Y3485 10X*

7.0 D31991 Bracket

HTT
HTT



S Comment: Qty.: 9.0000 Each(s)/Unit Total: 198.0000 Each(s)

Pick: Packing Kit

HTT Qty Part Number Description Batch
9 D3199-1 Bracket *42223 179X*

42271 18X

8.0 D32021 Cover



S Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

HTT Qty Part Number Description Batch
1 D3202-1 Cover *42224*

PC 8/2/08 (22)

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location: *B*

28/2/12 (19)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/12 JY

Job Completion



MF 08-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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WORK ORDER
NO. 42196

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description	
X						D412-698-019	BEARING OVERHAUL KIT	
	X					D412-698-021	REPLACEMENT SHIM KIT	
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH	
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH	
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT	
					X	D412-698-035	DOOR HANDLE KIT	
7						D3121-21	BOLT	
5						D3121-241	BEARING ASSEMBLY	
1						D3137-3	GUIDE	
1						D3137-5	WASHER	
2						D3183-045	BEARING ASSEMBLY	
3						D3238-1	SHIM	
1						D3238-3	SHIM	
2						D3238-5	SHIM	
6						D3238-11	SHIM	
2						D3238-13	SHIM	
4						D3238-15	SHIM	
						1	D3121-143	BRACKET ASSEMBLY
						1	D3121-144	BRACKET ASSEMBLY
						1	D3137-043	BRACKET ASSEMBLY
						1	D3183-043	BRACKET ASSEMBLY
						1	D3183-044	BRACKET ASSEMBLY
						1	D3202-3	COVER
						3	D3674-041	BRACKET ASSEMBLY
						9	D3675-1	BRACKET
						2	D3779-041	HANDLE ASSEMBLY
						2	D3779-3	PLATE
						2	D3779-043	HANDLE ASSEMBLY
						12	AN525-832R8	SCREW
						12	AN960JD10L	WASHER
						12	MS21042L3	NUT
						12	MS24694-S58	SCREW
1							MS24694-S101	SCREW

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At the
Tea Room
about
1000 ft.
above sea level
there is a
small drop
in the
valley